

# Work Order ID 77347

Tuesday, December 06, 2011 9:51:55 AM

**\*77347\***

ASAP

Page 1

Item ID: D4165-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Rib  
 Start Date: 12/6/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 12/8/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 11-12-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								

100 0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

2024 - 040

Memo

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

B11-17-6

②

110 QC2- Inspect parts off machine FAI/FAIB 0.00

**\*110\***

QC

Quality Control

Memo

0.00

B11-17-6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

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**\*77347\***

**Item ID:** D4165-5

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Item Name:** Aft Rib

Stop \*NS2\*

**Start Date:** 12/6/2011      **Start Qty:** 2.00

\*?\*

**Cust Item ID:**

**Required Date:** 12/8/2011      **Req'd Qty:** 2.00

\*~\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

140

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*140\***

## Packaging

## Memo

0.00

### Packaging

11

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

11/12/75 50 20

11/12/89

ME  
11-12-07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Tuesday, December 06, 2011 9:51:55 AM

Page 1

Work Order ID: 77347

Parent Item: D4165-5

Parent Item Name: Aft Rib

Start Date: 12/6/2011

Required Date: 12/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	69.8184	0.58	1.2210526			
<hr/>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		69.818421							
				117684		69.818421							
										<u>117684</u>			

# Dart Aerospace Ltd

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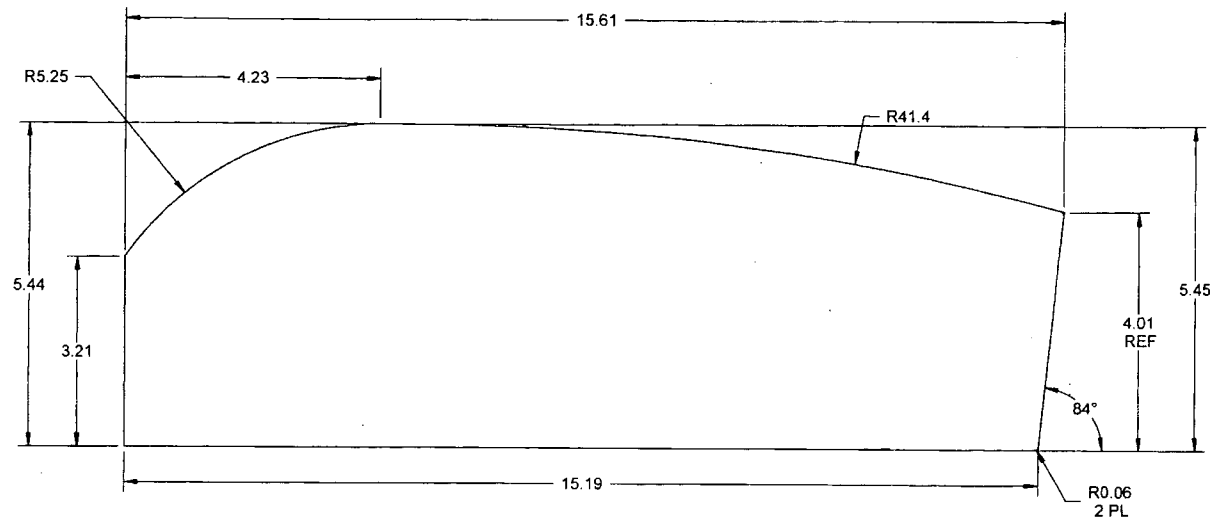
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4165-5 AFT RIB**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-34)

**RELEASED**  
2011-04-15  
JNP

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4165</b>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>VRD PARTS</b>	NTS
DATE	11.04.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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